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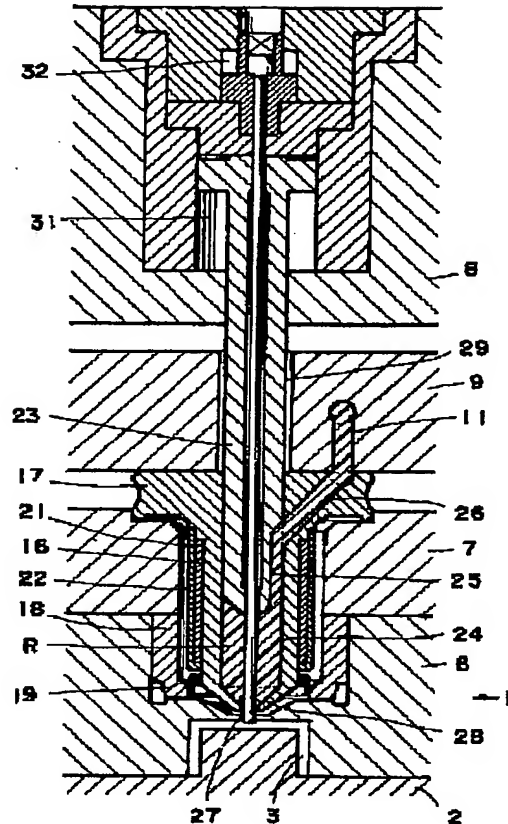
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APPLICANT : MITSUBISHI MATERIALS CORP;

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TITLE : INJECTION MOLDING METHOD



ABSTRACT : PURPOSE: To enable use of a low-pressure molding machine by shortening a molding cycle.

CONSTITUTION: A valve gate type mold is used. A plunger 23 is provided between a valve 28 and a valve easing 16. The plunger 23 is driven independently of the valve 28. Resin is injected through an injection molding machine under a state wherein a gate 27 is closed and a fixed quantity of the resin is reserved within the valve easing 16. Then along with opening a gate 28, the plunger 23 is moved forward and the resin R within the valve casing 16 is filled into the cavity 3 by a fixed quantity. Hereby, restrictions on timing of a measuring process on a molding machine side are reduced. In the case of multiple cavity mold, necessary pressure may be shared by the plungers 23 of every cavities 3 each. Supply of the resin within the valve casing 16 through the injection molding machine may be made at a low pressure.

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